

SPLIT

PRELIMINARY ISSUE

10,10,01



Work Order ID 61885-2

Wednesday, September 08, 2010 3:28:31 PM

Page 1

Item ID: D4181-1

Accept



Setup

Start



Revision ID: PRELIM

Item Name: Pod Frame Platform

Stop



Start Date: 9/8/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 9/13/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan:

Date: 10-8-08

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4181

PA1

0.00

MKT NOT PULLED



Waterjet

Memo

0.00

10-9-13

FLOW CNC Waterjet

1-Cut as per Dwg
Dwg Rev: P41
Prog Rev: P41

2-Deburr if necessary

(3)

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

10-9-13

Quality Control

Work Order ID 61885

Wednesday, September 08, 2010 3:28:31 PM



Page 3

Item ID: D4181-1

Accept



Setup

Start



Revision ID: PRELIM

Item Name: Pod Frame Platform

Stop



Start Date: 9/8/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 9/13/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

=) M 10/09/20

X3 ✓

Hand Finishing

Memo

0.00

140



Powdercoat

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

=) M 10/09/22

X3 ✓

Powder Coating

Memo

0.00

Start Time: 6:30 AM
Oven Temperature: 320 °F
Finish Time: 7:00 PM

150



QC

QC3- Inspect Part Finish

0.00

Quality Control

Memo

0.00

FT 10-09-22 X3

Work Order ID 61885

Wednesday, September 08, 2010 3:28:31 PM



Page 4

Item ID: D4181-1

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Pod Frame Platform

Start Date: 9/8/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 9/13/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

160

Identify as per dwg & Stock Location: *Composite*

Packaging

Memo

Set Up/
Run Hours

0.00

Accept
QtyReject
QtyReject
NumberInsp.
Stamp

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

*Repaired**RT**10/10/01**10/10/01**10-10-01*
*②*POSITIVE RECALL
EFFECTIVE 10-10-01 AUTH LL
RELEASED 10-10-01 DATE 10-10-01PER RELEASED DWG
DRAFTED 10-09-29

Picklist Print

Wednesday, September 08, 2010 3:28:36 PM

Page 1

Work Order ID: 61885



Parent Item: D4181-1



Parent Item Name: Pod Frame Platform

Start Date: 9/8/2010

Required Date: 9/13/2010

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A 10.09.08 new issue verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.250		Purchased	No			100	sf	0.0000	0.653	2.062105	3	10-9-13	

6061T6 SHEET .250

6061 T6B 0.250 x 6.000

M115217

M115217

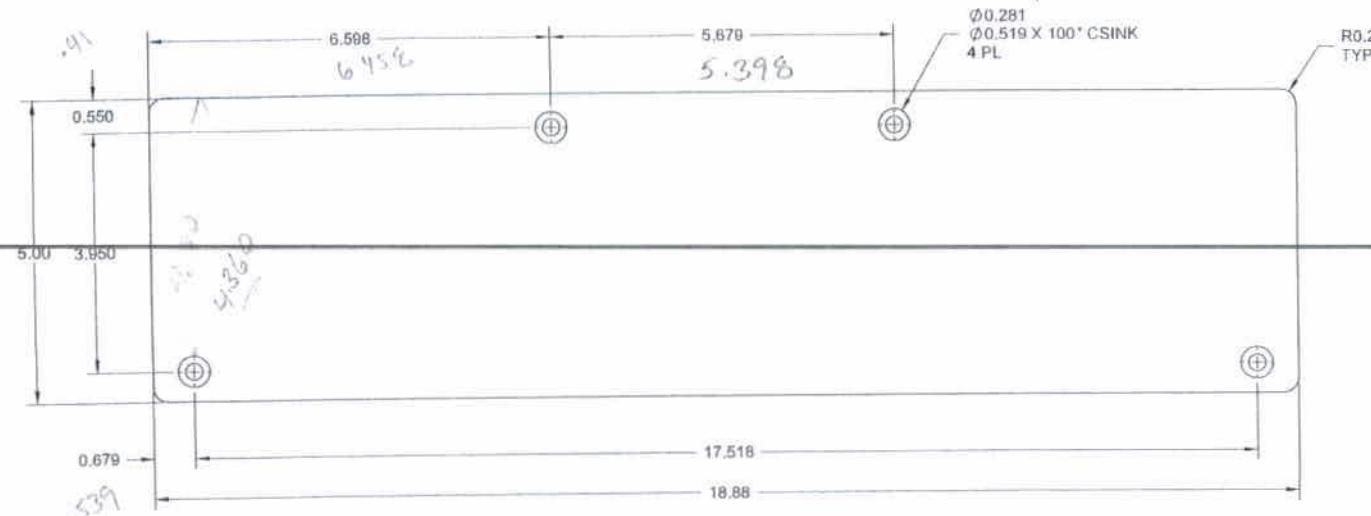
(3)

Route/Box/BX

✓
Done

8 7 6 5 4 3 2 1

D



D4181-1 POD FRAME PLATFORM

PRELIMINARY ISSUE

10.09.03

NOTES:

- 1) MATERIAL: 6061-T61/T62 ALUMINUM SHEET, 0.250 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF. DART SPEC. M6061T6S.250
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.29 lbs

41885
10-9-09

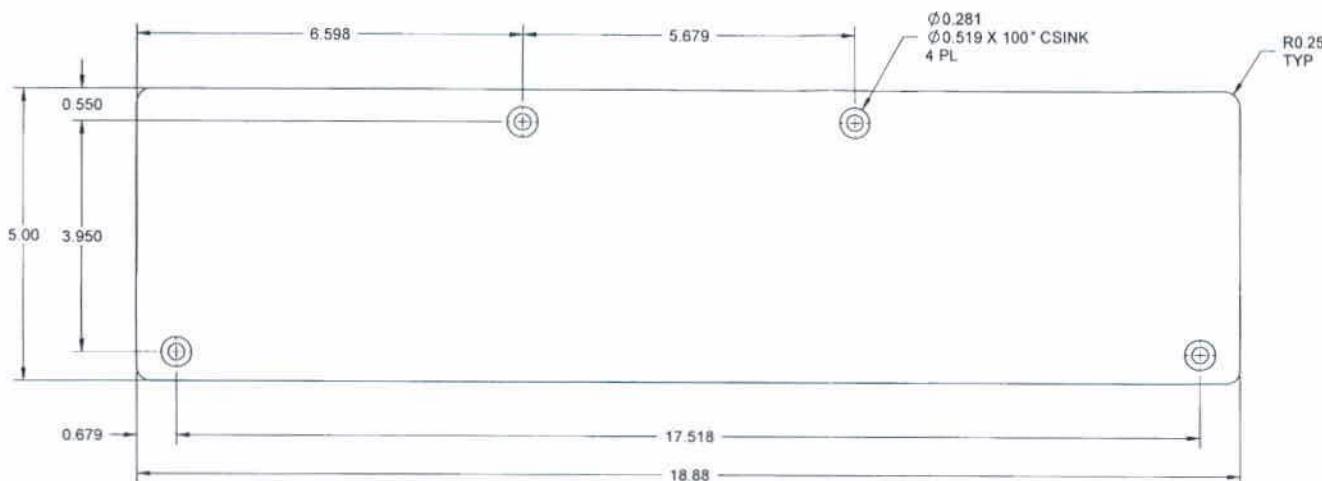
PA1	NEW ISSUE	MB	10.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>41885</i>		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.09.03	SCALE	NTS
D4181		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO.		REV. PA1	
SHEET 1 OF 1			
TITLE			
POD FRAME PLATFORM			
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DART AEROSPACE LTD	Work Order:	61885
Description: Bed FRAME PLATFORM	Part Number:	D4181-1
Inspection Dwg: D4181-1 Rev: P41		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measured by:	LB	Audited by:	S	Prototype Approval:	N/A
Date:	10-9-13	Date:	10/09/13	Date:	N/A
		Inspector to PGI Day on 4			
Rev	Date	Change		Revised by	Approved
A		New Issue		KJ/JLM	



D4181-1 POD FRAME PLATFORM

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- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.29 lbs

61885

RELEASED
2010-09-29
MP

A	NEW ISSUE	MB	10.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR	<i>[Signature]</i>	D4181	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	POD FRAME PLATFORM	NTS
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